

Date: Wednesday, 5/23/2007 3:24:38 PM
 User: Kim Johnston

Process Sheet

| | | | | |
|-----------------------|---|----------|------------------|-------------|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | DOOR WEDGE |
| Job Number | 32472 | | | |
| Estimate Number | 12110 | | | |
| P.O. Number | N/A | | Part Number | D32001 |
| This Issue | 5/23/2007 | S.O. No. | Drawing Number | D3200 REV A |
| Prsht Rev. | NC | | Project Number | N/A |
| First Issue | N/A | | Drawing Revision | A |
| Previous Run | 28106 | | Material | N/A |
| Written By | | | Due Date | 6/6/2007 |
| Checked & Approved By | <i>JL</i> 07.05.24 | | Qty: | <i>40</i> |
| Comment | Est Rev:A Removed from 9 Digit 06-01-25 JLM | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|----------------------------|
| 1.0 | MUHMWB10 | UHMW 1" Black | |
| | | Comment: Qty.: 0.0525 sf(s)/Unit Total : 1.0500 sf(s) UHMW 1" Black Material: Black UHMW 0.95" or 1.00" thick Use bearpaw scrap material (MUHMWB10) Identify for D3200-1 Batch: <i>M101254</i> | <i>and 07/09/13 40</i> |
| 2.0 | BAND SAW | BAND SAW | |
| | | Comment: BAND SAW Cut blank: 2.700" x 2.700 | <i>and 07/09/13 40</i> |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3200-1 as per Folio FA337 and Dwg D3200 2-Deburr | <i>and 07/09/13 40</i> |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | <i>and 1.5 07/09/18 40</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/09/20
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR WEDGE

Job Number: 32472

Part Number: D32001

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/19

(40)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 75

EJ (07/09/20) (40)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D (07/09/20) (40)

Job Completion



W 07/09/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 32472 |
| Description: Door Post Block | Part Number: | D3200-1 |
| Inspection Dwg: D3200 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

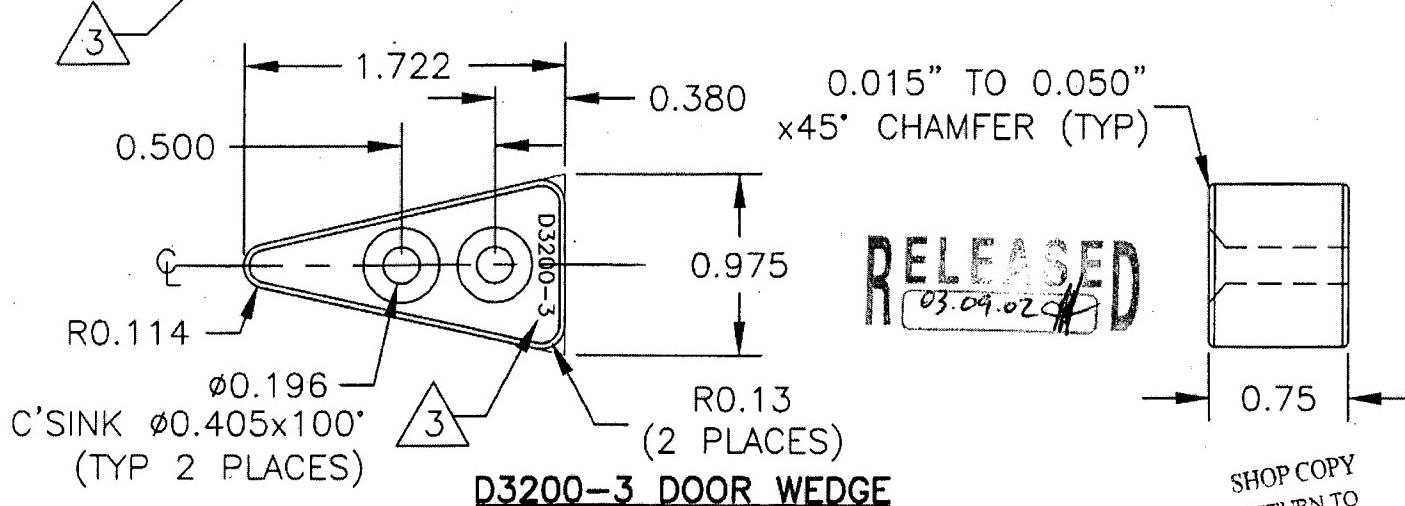
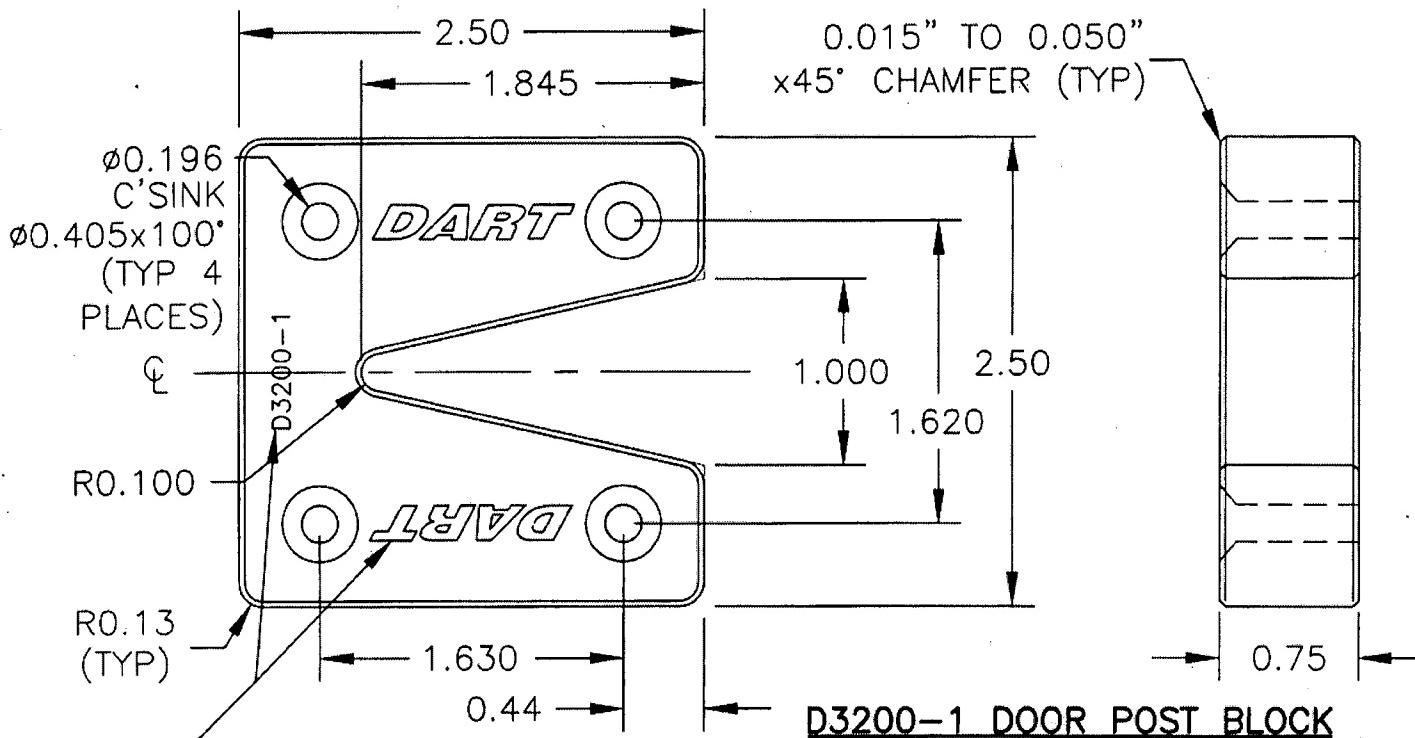
3-6
07/09/18

| | | | | | |
|--------------|--------------------|-------------|--------------------|---------------------|-----|
| Measured by: | <i>[Signature]</i> | Audited by: | <i>[Signature]</i> | Prototype Approval: | N/A |
| Date: | 07/09/17 | Date: | 07-09-17 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| A | 03.11.12 | New Issue P/O D412-698-015 | KJ/RF | JF |

DART

| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. A |
| # | # | D3200 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 03.08.06 | | DOOR WEDGE | 1:1 |
| A | 03.08.06 | NEW ISSUE | |

D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32472

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